

Split.

Customer	: 32375 ²			Part Number	: D2646	Qty:	16	Unit:	Each
Job Number	: 10312			Drawing Number	: D2646 REV C				
Estimate Number	: N/A			Project Number	: N/A				
P.O. Number	: 5/16/2007			Drawing Revision	: C				
This Issue	: NC			Material	: N/A				
Prsht Rev.	: N/A			Due Date	: 6/5/2007				
First Issue	: 31335			Type	: PURCHASED PARTS				
Previous Run	: 31335								
Written By	: <u>07.05.16</u>								
Checked & Approved By	: <u>07.05.16</u>								
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev: H Changed Inserts 07.02.19 JLM								

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
<div>Comment: PURCHASING Issue P/O: <u>3794</u> 1-Spin as per Dwg D2646 2-Material release note required</div> <div><u>07/05/16</u> (16)</div>		
2.0	D2646P	Aft Cap
<div>Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s) AFT CAP</div>		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
<div>Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached</div> <div><u>07/06/05</u> (16)</div>		
4.0	QC6	DIMENSIONAL CHECK
<div>Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646</div> <div><u>07.06.12</u> (16)</div>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<div>Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to <u>250</u> and <u>250</u> as per Dwg D2646. 3-Deburr <u>297</u> <u>07.06.11</u></div> <div><u>07/06/12</u> (16)</div>		

Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

JS

07-06-13

16

7.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

P/D: 4058 c207/06/27 (2)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

07-07-03 (2)

9.0 AL\$71032130 Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

INSERT

Batch: M103618

JS

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

JS 07-07-04 (2)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-07-04 (2)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

JS 07-07-04 (2)

Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

R 07/07/07

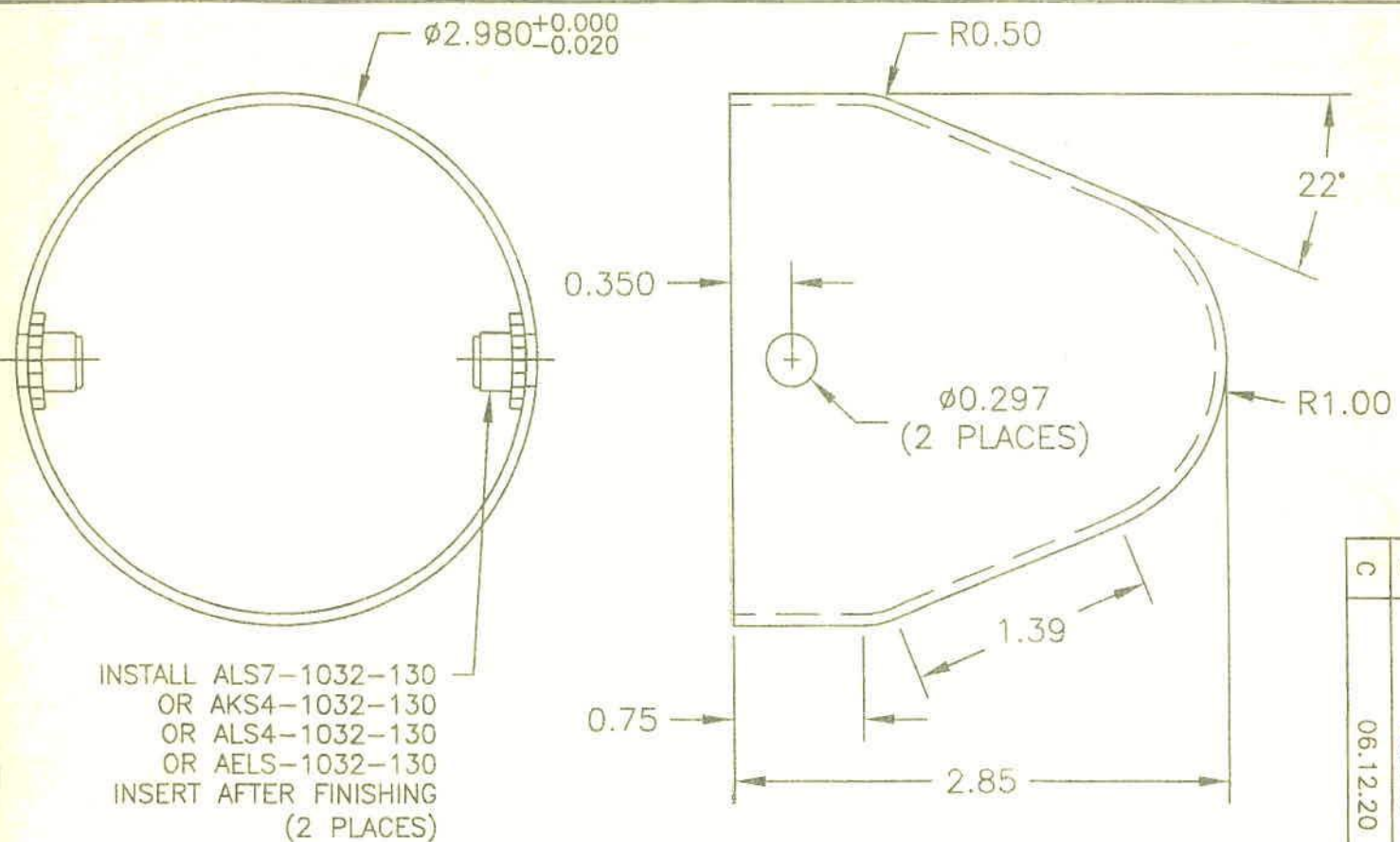
Job Completion



u 07-07-06

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1	
A		97.03.25	NEW ISSUE			
B		05.04.01	CHANGE TO CLOSED INSERTS			
C		06.12.20	CHANGE TO OPEN ENDED INSERTS			

**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

07.01.20
REWORKED

UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
NO. 32375



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST BLEVEN MILK ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	099792			MILL FINISH
ITEM NO	1	PART NO	050393-8			NO ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT STANDARD MILL FINISH
GAUGE	0.0630	WIDTH	48.0000	LENGTH	0.0000	IN STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 238066 COIL: R01 DROP: 440525

INCOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
440525	0.11	0.42	0.08	0.02	0.002	0.001	0.014	0.001	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF
ASME SB209 1100 O, AMS 4001H 1100 O
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten:
HAW
Henry @ SHR
C/O
Zoe @
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met these requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

DREW FREEDY, LAB SUPERVISOR



Sieg's Manufacturing Ltd.



Metal Spinning and Fabricating

6236 - 205 STREET LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: June 4/07
Customer: Dart Aerospace
Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By:
B32375	16 ✓	14G1100	N/A	✓	
B32427	50	14G1100	N/A	✓	

Notes:



Material Certification Attached: Yes.

